

Date: Tuesday, 01/04/2008 12:42:09 PM  
User: Jean-Luc Menard

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	PLUG		
Job Number	38273			Part Number	D26511		
Estimate Number	10512			Drawing Number	D2651 REV. B		
P.O. Number				Project Number	N/A		
This Issue	01/04/2008	S.O. No.		Drawing Revision	B		
Prsht Rev.	NC			Material			
First Issue	/ /	Type	MACHINED PARTS	Due Date	08/04/2008	Qty:	500
Previous Run	33349			Um:	Each		
Written By	<i>J.F. 08.04.07.</i>						
Checked & Approved By							
Comment	Est: A 02.04.15 New Issue NG						
	Est: B 05.12.12 added deburr EC						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M6061T6R0500	6061-T6 Round Bar .500"
Comment: Qty.: 0.0421 f(s)/Unit Total : 21.0525 f(s) Material: 6061-T6 (QQ-A-225/8) 0.500" Dia (M6061T6R0500) Batch: <u>M 105671</u> <span style="float: right;">J.F. 08/04/07 (570)</span>		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
Comment: HAAS CNC VERTICAL MACHINING #1 1- Turn as per Folio FA219 and Dwg D2651  2- Deburr <span style="float: right;">J.F. 08/04/07 (570)</span>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <span style="float: right;">J.F. 08/04/07 (570)</span>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <span style="float: right;">J.F. 08/04/07 (570)</span>		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr as per dwg D2651 <span style="float: right;"><i>W/J. Jaff</i> 08-05-07</span>		

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 08/04/07 570

7.0 POWDER COATING POWDER COATING



POWDER COATING

M107550

570X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3  
(Only larger section necessary)

M.1/BL 08/04/09

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL 08/04/09

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP 1

M.1 08/04/09

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/10 JH

Job Completion



U 8/04/10



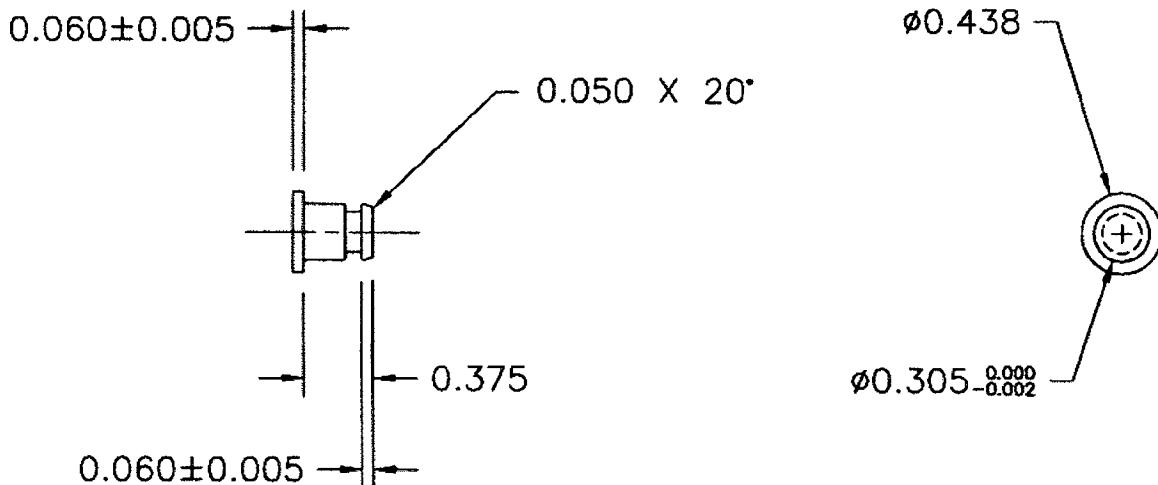
copy  
only

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2651	SHEET 1 OF 1
DATE		TITLE	SCALE
03.12.19		PLUG	1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

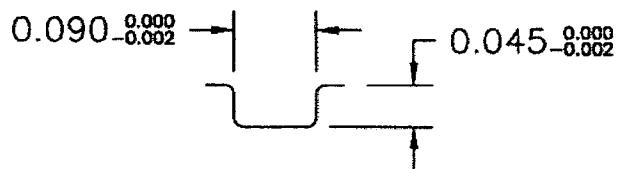
RELEASED

03.12.19

### D2651-1 PLUG:



### GROOVE DETAIL (SCALE 5:1)



### D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

### D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER  
3/16 ID, 5/16 OD, 1/16 WIDTH  
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

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DART AEROSPACE LTD	Work Order:	38273
Description: Plug	Part Number:	D2651-1
Inspection Dwg: D2651 Rev: B		Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article      Prototype

Measured by:	J.F	Audited by:	120	Prototype Approval:	N/A
Date:	08/04/05	Date:	08/04/05	Date:	

Rev	Date	Change	Revised by	Approved
A	03.12.22	New Issue	KJ/RF	FF